

# Work Order ID 70232

Wednesday, June 01, 2011 11:07:12 AM



ASAP

Page 1

Item ID: D3255-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MP Date: 11-06-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3255	Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 \*\*\*purge weld\*\*\* A/R SS ROD  
Batch: 115928 □2-Grind Welds Flush

Pl 11-06-01 (1x)

110

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8 11/06/02

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 11/06/02

(x1)

542

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID:	D3255-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	6/1/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/2/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p>Memo</p> <p>START TIME: 8:45</p> <p>FINISH TIME: 9:15</p> </div> <div> <p>OVEN TEMPERATURE:</p> </div> </div>									
140  QC	QC3- Inspect Part Finish	0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p>Memo</p> </div> <div> <p>QC</p> </div> </div>									
150  Small Fab	Small Fab	0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p>Memo</p> <p>I-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg</p> <p>D3255 A/R 736 DOW CORNING ADHESIVE</p> <p>Batch: M116664</p> </div> <div> <p>85 u6c63</p> </div> </div>									

1X M 11/06/02

1 BR 11-6-2

M 11 5128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 70232**

Wednesday, June 01, 2011 11:07:12 AM



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Item ID: D3255-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/06/03

②

012

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PPA 70233

0.00

Packaging

11/6/3

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/3

mc  
11-06-03

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Wednesday, June 01, 2011 11:07:09 AM




Page 1

[illegible][illegible]

**Required Date:** 6/2/2011

**Required Qty: 1.00**

**Comments:** IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2  Panel		Manufactured	No			100	Each	7.0000	1	1		Pl 11.06.01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					69054			6					
				WA025				1					
					61686			1					
D3255-3  Cap		Manufactured	No			150	Each	17.0000	1	1		Pl 11.06.01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA021				17					
					66812			17					
D3255-5  Gasket		Manufactured	No			100	Each	14.0000	1			Pl 11.06.01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				14					
					66574			2					
					68783			12					

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

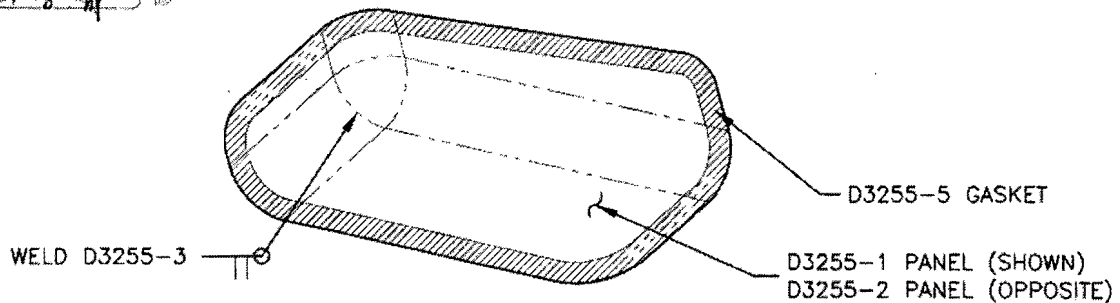
**NOTE:** Date & initial all entries



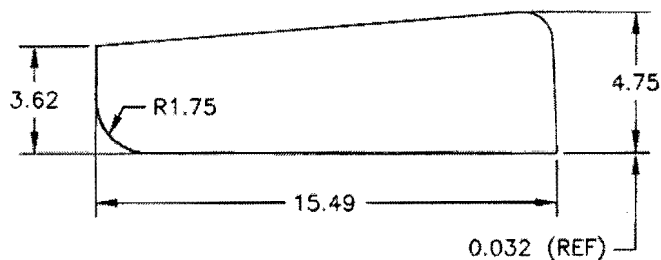
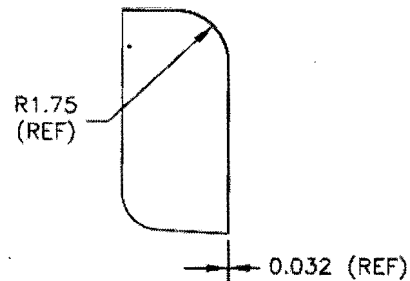
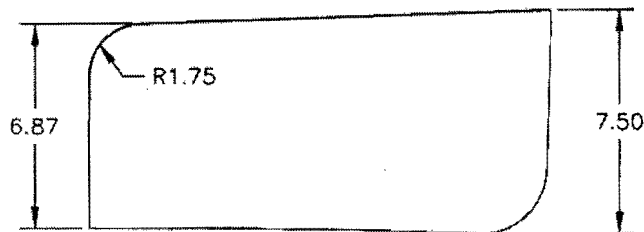


DESIGN R#	DRAWN BY R#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED  
05-01-18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

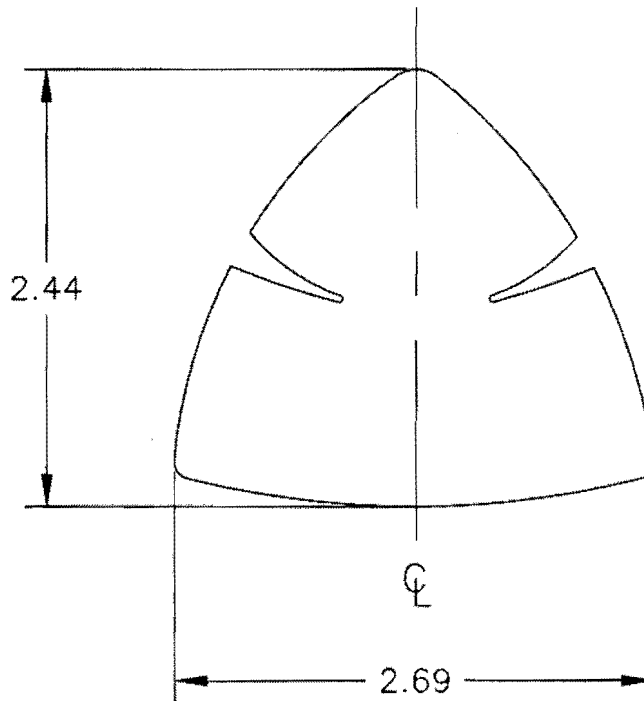
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05-01-18 [Signature]



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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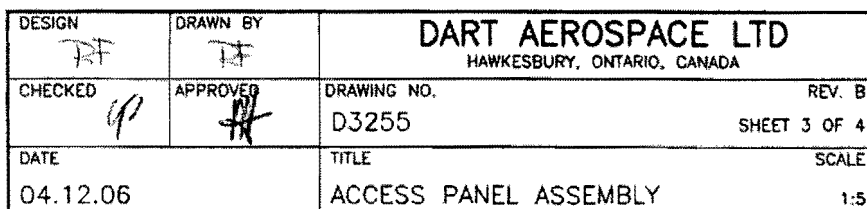
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

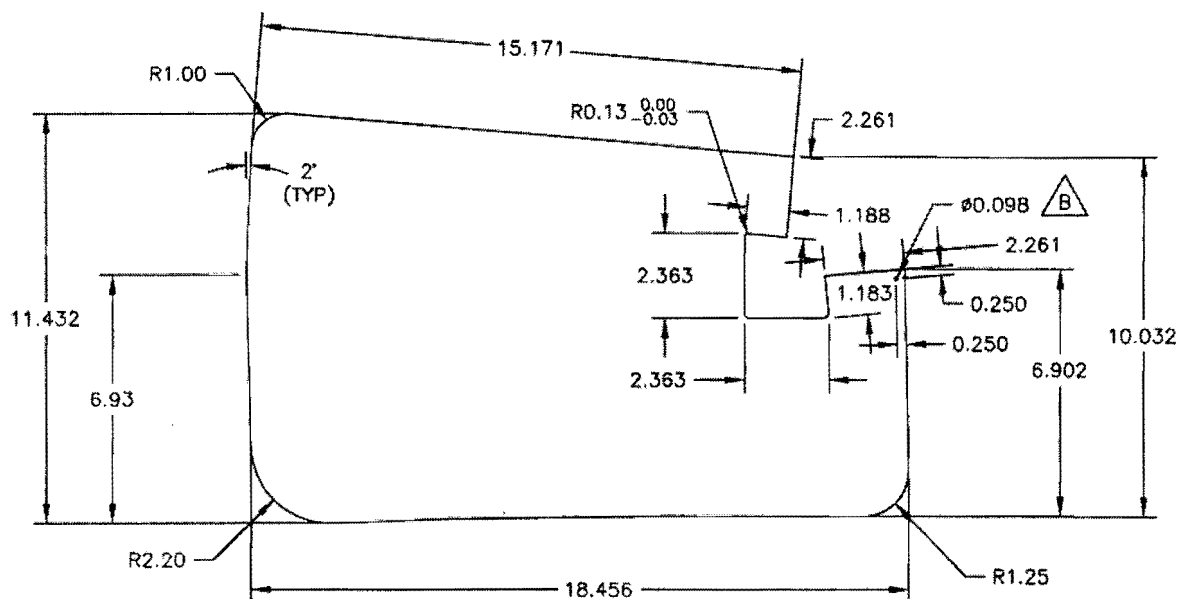
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



RELEASED  
05-01-18



D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

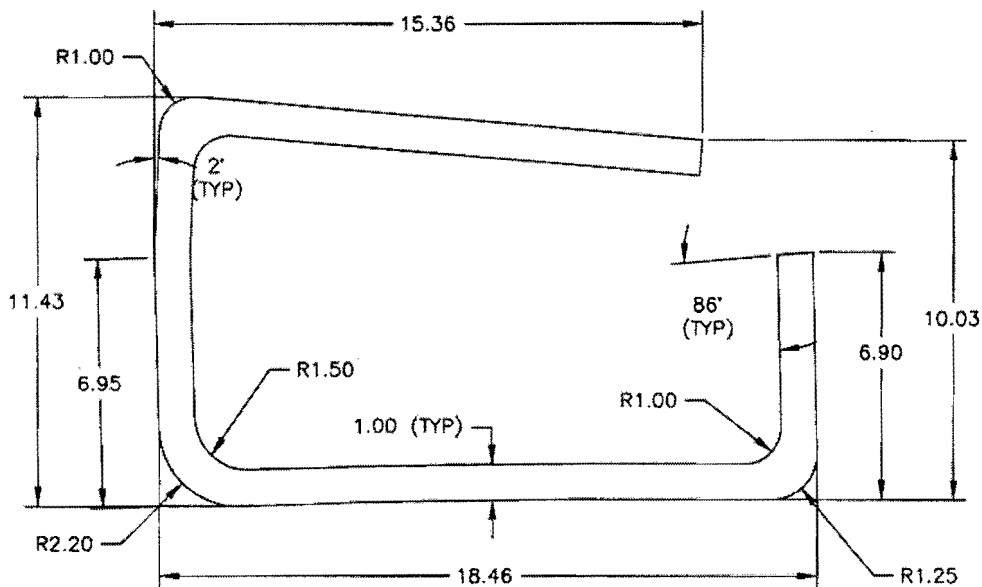
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JT	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05 01 18 #



### D3255-5 GASKET

#### D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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